

SHIP 07/14

Work Order ID 163576

163576

Page 1

Thursday, June 29, 2017 3:00:13 PM

Item ID: D3043-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Weldment RH

Start Date: 7/5/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/17/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date: JUN 29 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3043

Rev A

100

0.00

100

Large Fab

Large Fab

Memo

1.46

Large Fab

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G
2-Deburr and bevel ends for welding

2x DC 2017-07-17

110

0.00

110

QC6- All purchased or subcontracted products

QC

Memo

0.00

Quality Control

2 JUL 19 2017

DAS
24
9-89

120

0.00

120

Large Fab

Large Fab

Memo

1.40

Large Fab

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808
AR AL ROD Batch: 137078
2-Grind Fwd End Cap weld flush

2 JUL 19 2017

DAS
24
9-89

Work Order ID 163576***163576***

Page 2

Thursday, June 29, 2017 3:00:13 PM

Item ID: D3043-042**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Step Weldment RH**Start Date:** 7/5/2017 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 7/17/2017 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

② 11.07.20 RD

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.04

Quality Control

② 11.07.20 RD

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.74

Hand Finishing

X2RH of RD 12/02/20

Thursday, June 29, 2017 3:00:13 PM

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Weldment RH

Start Date: 7/5/2017 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 7/17/2017 **Req'd Qty:** 2.00 ***Q***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Large Fab

0.00

Large Fab

Memo

Large Fab

1-1-Weld 1 End Cap as per OSI 004 & Dwg

AR AL ROD Batch: 37078

2-Inspect for foreign object as per QSI 024

3-Grind Fwd End Cap weld flush

170

QC10- Inspect visual per QSI004- ground welds	0.00
---	------

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

180

QC

Memo

0.04

Quality Control

DAS
38
9-89
20 201

UAS
38
9-89
JUL 20 2011

Work Order ID 163576

Thursday, June 29, 2017 3:00:13 PM

163576

Page 4

Item ID: D3043-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment RH
Start Date: 7/5/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/17/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Touch up alodine Memo	0.00 0.17				2RH	d	ll	12/6/20
210 *210* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum N137176 Memo START Time: 2:45pm OVEN TEMPERATURE: 320° F FINISH TIME: 3:15pm	0.00 0.62				2RH	d	ll	14/6/20
220 *220* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch N137496 Memo	0.00 0.79				2RH	d	ll	14/6/20

Work Order ID 163576

Thursday, June 29, 2017 3:00:13 PM

163576

Page 5

Item ID: D3043-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment RH
 Start Date: 7/5/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/17/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							DAS 38 9-88
230						2			JUL 25 2017
QC	Memo	0.02							
Quality Control									
240	Identify as per dwg & Stock Location: <u>PK6</u>	0.00							
240						2			JUL 26 2017
Packaging	Memo	0.02				DAS 6 9-88			
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									17/7/26 JH
QC	Memo	0.20							
Quality Control									

DAS
21
9-88
JUL 26 2017

Picklist Print

Thursday, June 29, 2017 3:00:13 PM

Page 1

Work Order ID: 163576

163576

Parent Item: D3043-042

D3043-042

Parent Item Name: Step Weldment RH

Start Date: 7/5/2017

Required Date: 7/17/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

51.5000

1

2

D2622-120C

Step Extrusion

**

DC 2017-07-17

Location

Loc Qty

Loc Code

WA003

51.5

B152316 → 2

152316

18.5

157441

33

D2734

Manufactured

No

120

Each

91.0000

1

2

D2734

Step End Plate

**

DC 2017-07-17

Location

Loc Qty

Loc Code

WA003

91

B162890 → 2

161519

71

162890

20

D2734

Manufactured

No

160

Each

91.0000

1

2

D2734

Step End Plate

**

DC 2017-07-17

Location

Loc Qty

Loc Code

WA003

91

161519

71

162890

20

D3040-1

Manufactured

No

120

Each

16.0000

2

4

D3040-1

Mounting Lug

**

DC 2017-07-17

Location

Loc Qty

Loc Code

WA003

16

B127079 → 2

125837

10

127079

6

B125837 → 2

DAS
24
9-89

JUL 27 2017

Picklist Print

Thursday, June 29, 2017 3:00:13 PM

Page 2

Work Order ID: 163576

163576

Parent Item: D3043-042

D3043-042

Parent Item Name: Step Weldment RH

Start Date: 7/5/2017

Required Date: 7/17/2017

Start Qty: 2.00

Required Qty: 2.00

✓ D3040-3

Manufactured No

120

Each

32.0000

2

4

D3040-3

**

Mounting Lug

26 2017-07-17

Location

Loc Qty

Loc Code

WA003

32

9

20

3

127080

128957

83998

B127080 → 4



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. 4 SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163576

JUN 29 2017

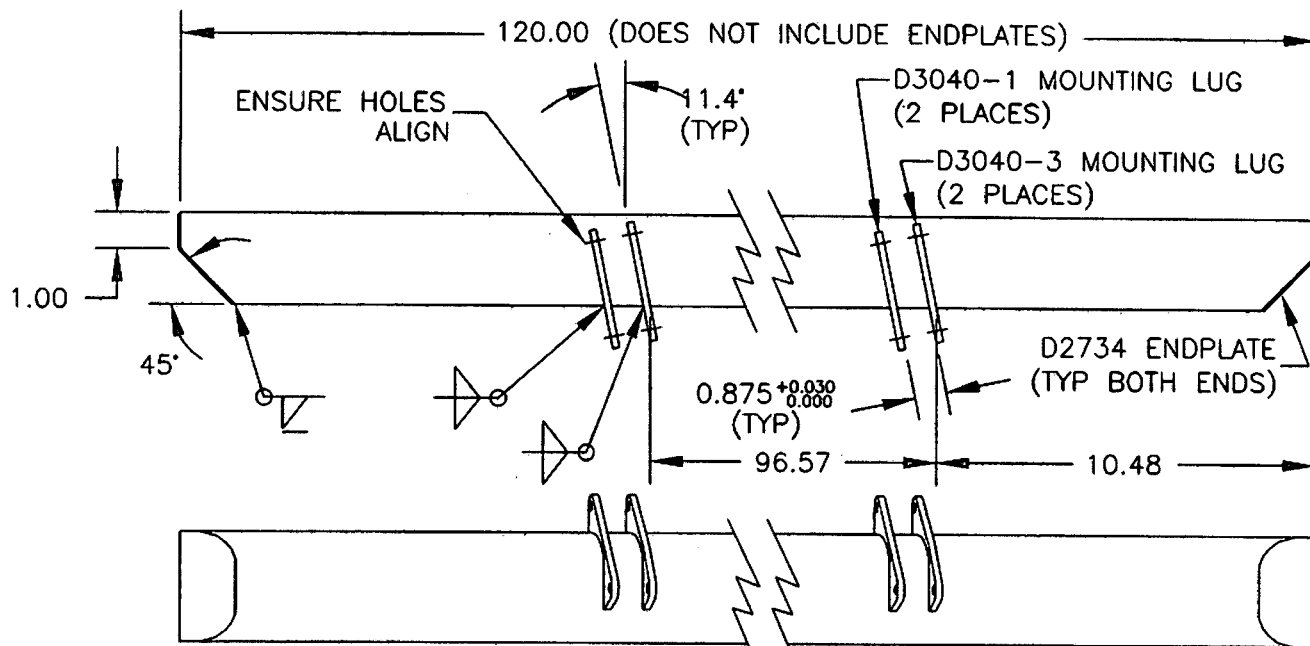
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01.07.05

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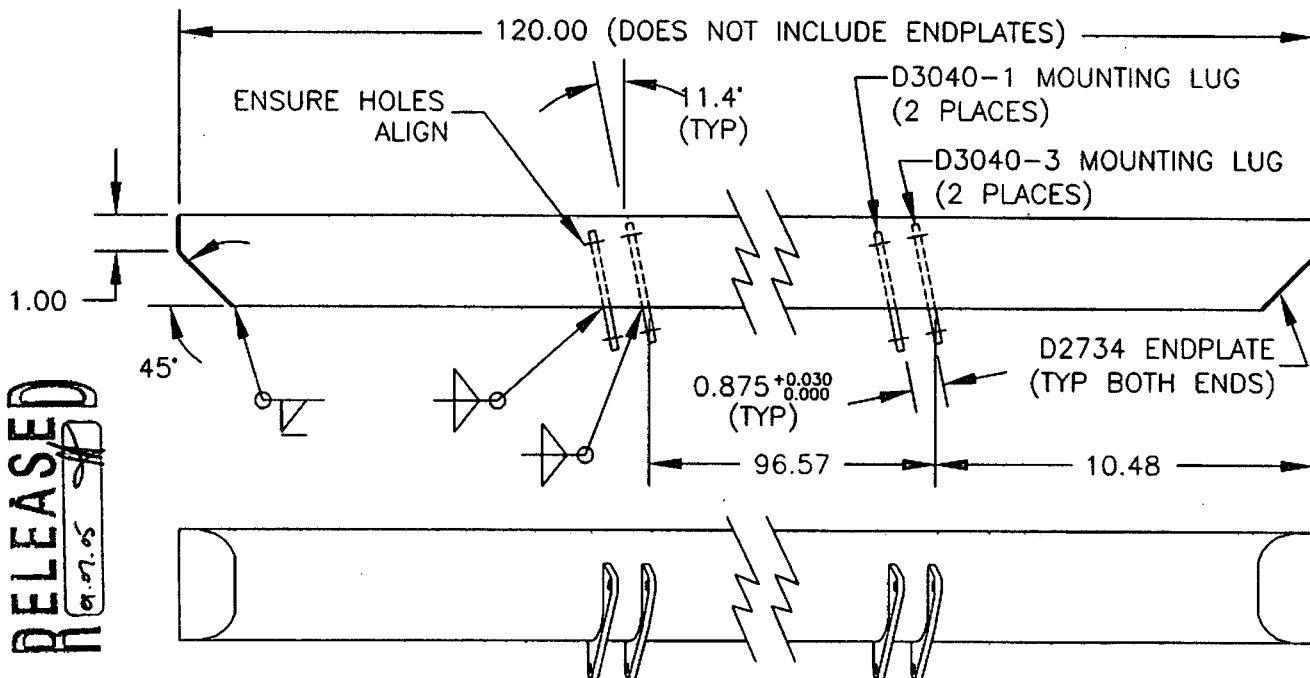
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CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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01.07.05

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